

Work Order ID 64355

Monday, December 06, 2010 3:24:28 PM



Page 1

Item ID: D4110-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler, RH

Start Date: 12/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: *12-2-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4110	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg ***make from D4110-1***

Dwg Rev: *A*

Prog Rev: *A*

304 .063

2-Deburr if necessary

B 10-12-17

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-12-17

Work Order ID 64355

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Page 2

Item ID: D4110-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Doubler, RH

Start Date: 12/2/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/17

8/50/12/21 (6)

8/10/12/21

(6)

-23

Work Order ID 64355

Page 3

Monday, December 06, 2010 3:24:28 PM

Item ID: D4110-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler, RH

Start Date: 12/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 130

0.00



Packaging

Memo

0.00

Packaging

10/12/21 (6)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21 MF

10-12-21

Picklist Print

Monday, December 06, 2010 3:24:32 PM

Page 1

Work Order ID: 64355

Parent Item: D4110-2

Parent Item Name: Door Doubler, R.I



Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

124.0000

0.0318

0.200842



304/316 Sheet .063



1310-12-17

Location

Loc Qty

Loc Code

MAT

124

111323

0

115953

124

115953

DART AEROSPACE LTD	Work Order:	64355
Description: DOOR Doubled R.H.	Part Number:	D4110-2
Inspection Dwg: D4110-2, Rev: A		Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

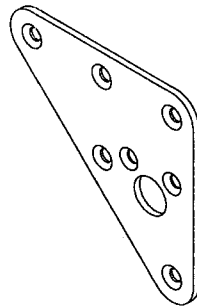
Measured by:	HB
Date:	10-12-77

Audited by:	
Date:	10/2/17

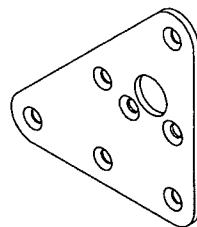
Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

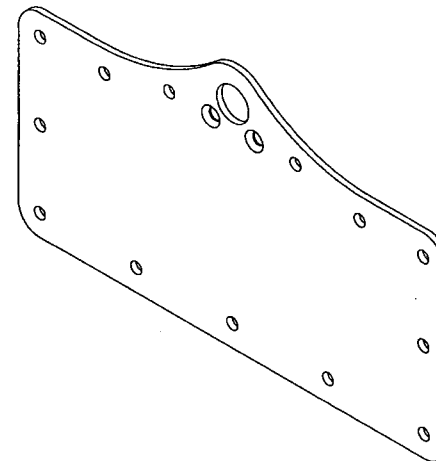
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 64355
PS10-10-6



D4110-1 DOUBLER, LH DOOR



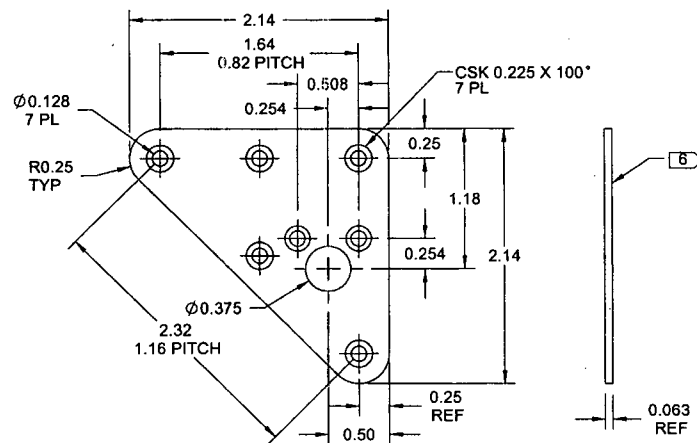
D4110-2 DOUBLER, RH DOOR



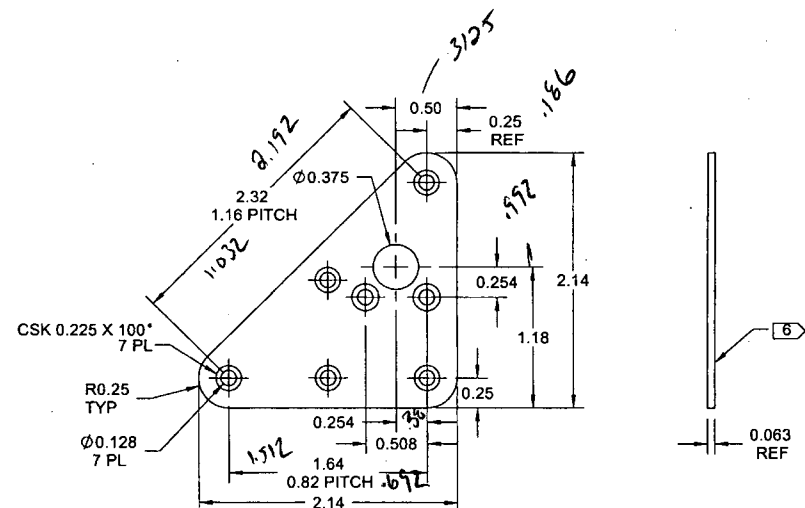
D4110-3 DOUBLER, SILL

RELEASED
 2010-09-23
IND

A	NEW ISSUE	JPH	10.07.20
REV:	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4110 REV. A SHEET 1 OF 3 TITLE DOUBLER SCALE NTS	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DATE 10.07.20	
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D4110-1 DOUBLER, LH DOOR



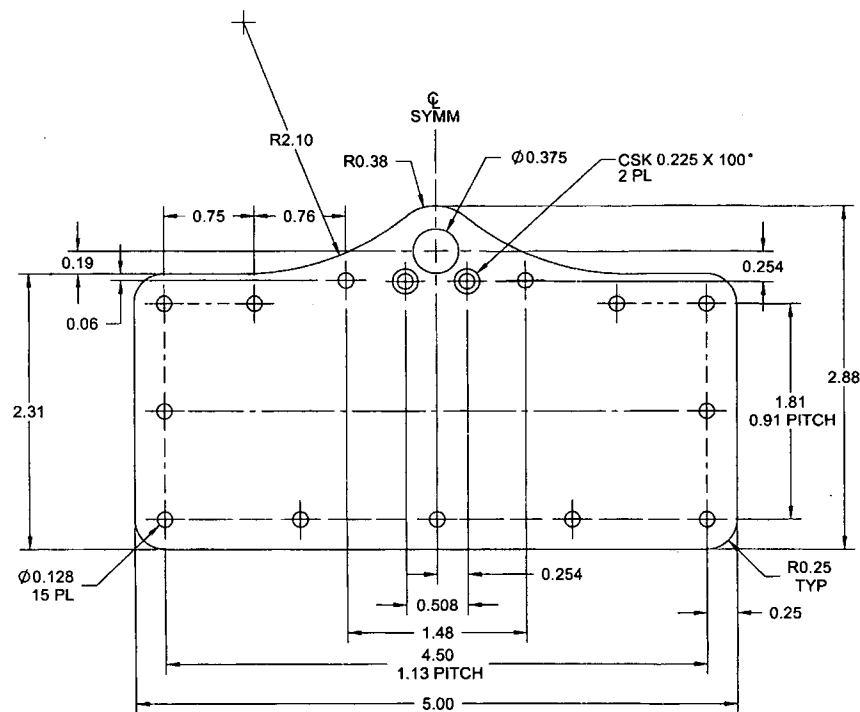
D4110-2 DOUBLER, RH DOOR

NOTES:

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.05 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4110	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLER	NTS
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RELEASED
2010-09-23



D4110-3 DOUBLER, SILL

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4110	REV. A
MFG. APPR.	JPH	TITLE DOUBLER	SHEET 3 OF 3
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